

# Work Order ID 56900

March 17, 2010 1:46:20 PM



Page 1

Item ID: D3696-041

Revision ID:

Item Name: Arm Assembly

Start Date: 12/03/2010 Start Qty: 4.00

Required Date: 26/03/2010 Req'd Qty: 4.00

Reference: *10-03-16*

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



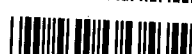
QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3696

Rev C

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blank 17.600" long

0.00

0.00

*10/04/28*

*4*

105



HAAS 1

HAAS CNC vertical machine #1

Memo

MILL AS PER DWG AND FOLIO FA918

FOLIO REV: *C*

DWG REV: *C*

DEBURR

0.00

0.00

*10/04/29*

*4*

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Accept

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Customer:

Setup Start

Stop

Run Start

Stop

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

MW  
10/04/29

4

0

130

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

G.A  
10/04/29

4

0

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

H-BR 10-5-41

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Required Date: 26/03/2010 Req'd Qty: 4.00

Reference:

Accept



Setup Start

Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

M112589

0.00

Memo

0.00

⇒ M 10/05/04

4

1- mask prior to painting as per dwg (see note 8) START TIME:  
2.45pm OVEN TEMPERATURE: 3:15pm FINISH  
TIME: 320°C

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

⇒ M-k 10/05/05

(4X)

170



Small Fab

Small Fab

Small Fab

0.00

Memo

0.00

1-Install Helicoil 112-Press Bushing 113-Install Plunger

⇒ M-k 10/05/10

(4X)

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Approvals:

Process Plan:

Date:

QC:

Date:

Accept

Tooling:

Date:

SPC (Y/N):

Date:

Setup Start

Stop

Run Start

Stop

Cust Item ID:

Customer:

Page 4

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00				(44)			
190 Packaging Packaging	Identify as per dwg & Stock Location: <u>255</u>  Memo	0.00 0.00							
200 QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							

1005-22 (44) SP

10/05/13 JF  
10-5-12 (4)

# Picklist Print

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Page 1

Work Order ID: 56900

Parent Item: D3696-041

Parent Item Name: Arm Assembly

Comments: IPP Rev:A New Issue 08-05-01 JLM Verified By:EC  
IPP Rev:B 08-07-22 redesign part (prelim) DD verified by:EC IPP  
REV:C NOW ON CNC MILL 10-03-17 JLM VERIFIED BY:DD

Start Date: 12/03/2010

Required Date: 26/03/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/  
D3799-1

Replacement

Mfg/

Bin  
No

Primary

Last

Route

Unit of  
Each

Qty on  
52.0000

Remaining  
4.0000

Qty

Date

Status



Oilite Bronze Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST088

44915 ✓

52

52

Each

16.0000

4.0000



~~4x~~ m-k 10/05/10

D3801-3



Hand Retractable Spring Plunger

Manufactured

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST088

55571 ✓

16

16

f

4.0700

6.1231



~~4x~~ m-k 10/05/10

M7075T6B1.000X1.000



7075 T6 BAR 1.00x1.00

Purchased

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

107984

4.07

4.07

~~6.1231~~ m-k 10/03/24

7075T6B1.00x1.00

Mat 114415 → 6,1231 ~~DT~~ 10/04/28

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Start Date: 12/03/2010

Required Date: 26/03/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS21209C8-20		Purchased	No				Each	152.0000	4.0000			
												
Heli Coil Insert												

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST305

108066 ✓

152

152

~~4X~~ m-1  
 10/05/10

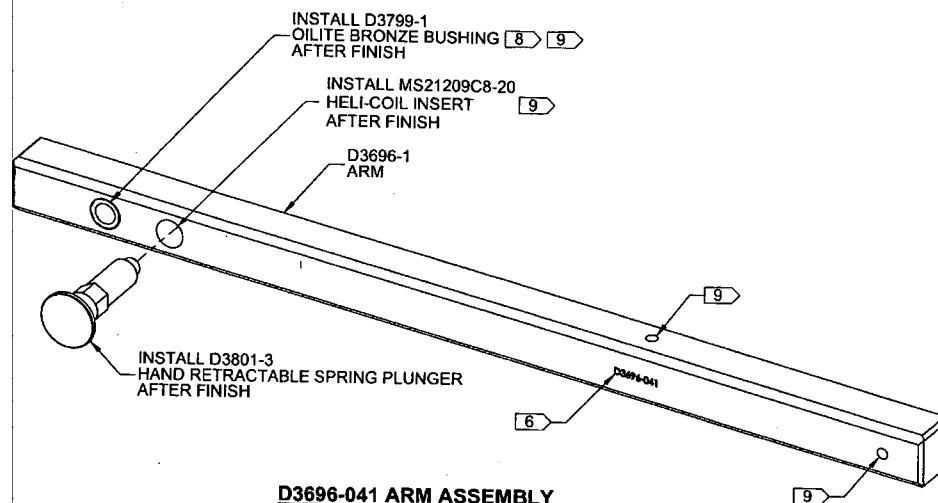
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Shop Packet Print

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ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3696-041	ARM ASSEMBLY
5	1	D3696-1	ARM
6	1	D3799-1	OILITE BRONZE BUSHING
7	1	D3801-3	HAND RETRACTABLE SPRING PLUNGER
11	1	MS21209C8-20	HELI-COIL, SCREW LOCKING (RED)



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 50900  
10-3-12

RELEASED  
9/16/2012

**D3696-041 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3696-041" USING FINE POINT PERMANENT INK MARKER LOCATED APPROXIMATELY AS SHOWN
- 7) WEIGHT: 1.69 lbs
- 8) FACE D3799-1 OILITE BRONZE BUSHING FLUSH TO D3696-1 ARM AS REQUIRED ON BOTH SIDES PRIOR TO POWDER COATING
- 9) MASK HOLES AS SHOWN PRIOR TO POWDER COATING

C	REVISED ITEM 5 AS FOLLOWS: "Ø 0.201 THRU CBORE Ø 0.500 X 0.300 DP" WAS 2 PL (ZN C4-2). REASON: REDESIGNED ARMREST CUSHION BASED ON FEEDBACK FROM END USERS AT HAI 2009	MB	09.06.17
B	P/N D3799-1 WAS BNT-137 (ZN D6-1); P/N D3801-3 WAS PRT-12 (ZN C7-1). REASON: PURCHASED PARTS NOW PROCURED THROUGH D3799 AND D3801 SPEC CONTROL DRAWINGS, ADDED Ø 0.201 HOLE AND CBORE (ZN C6-2 AND D5-2); 17.50 WAS 19.50 (ZN B5-2); 1.000 WAS 0.990 +0.000/-0.010 (ZN C2-2); POCKETS REMOVED REASON: ELIMINATED FWD-AFT ARMREST ADJUSTMENT	MB	08.07.17
A	NEW ISSUE	MB	08.04.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.17		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3696</b> TITLE <b>ARM ASSEMBLY</b> REV. C SHEET 1 OF 2 SCALE NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



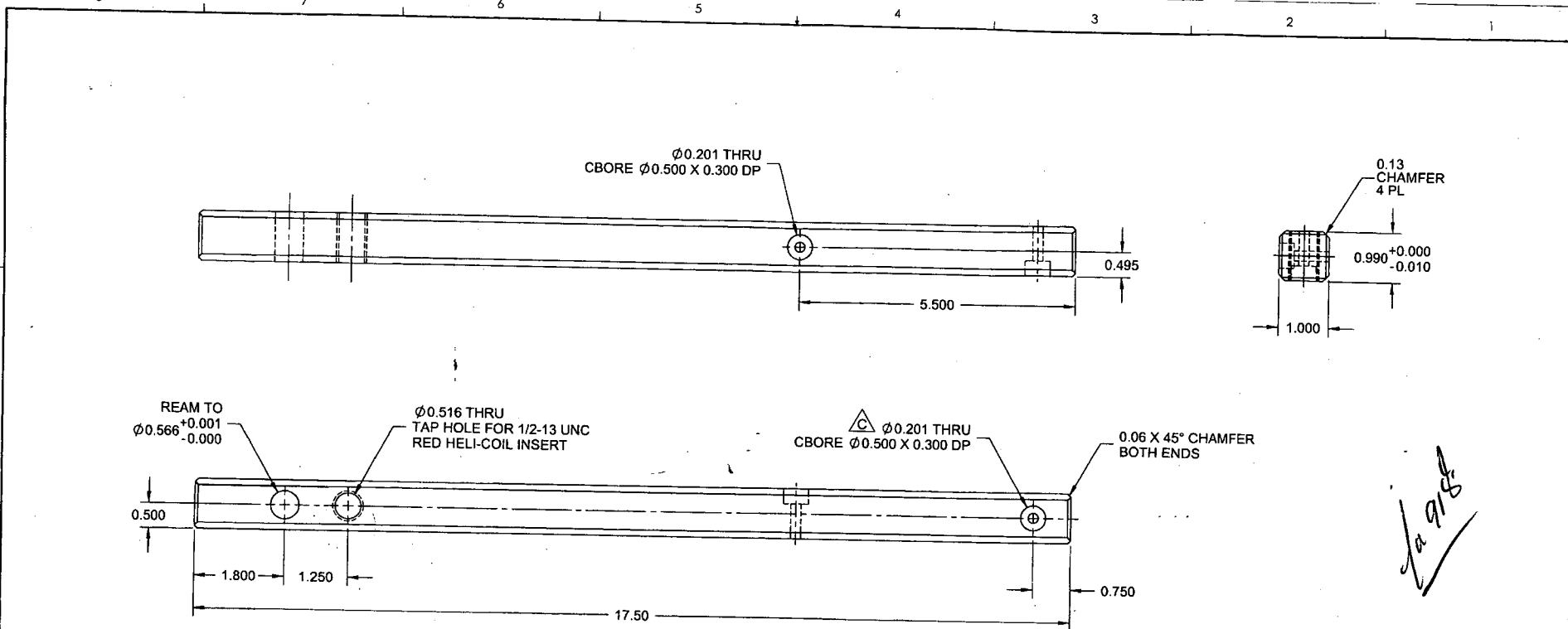
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries.



**D3696-1 ARM**

*W/5 56900*

**RELEASED**

**D3696-1 NOTES:**

- 1) MATERIAL: 7075-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR  
PER AMS-QQ-A-225/9 (OR AMS 4122/4123/4186/4187) OR  
PER AMS-QQ-A-200/11  
REF. DART SPEC. M7075T6B
- 2) FINISH: SEE SHEET 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.63 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3696	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ARM ASSEMBLY	NTS
DATE	09.06.17	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries